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D4634-145
Job Sheet 167078-B



Part No: D4634-145

Job Qty: 1 ea

Part Name: Aft, Center Ceiling Replacement Panel Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	1 Ea		11/9/17	0.00	0.00	Start up container	
100	HandThermo	1 pcs		11/9/17	0.00	1.65	HandFinish4	D.M.L 17-12-20
110	Small Fab	1 pcs		11/10/17	0.00	1.47	Small Fab	D.M.L 17-12-20
120	QC	1 pcs		11/10/17	0.00	0.00	QC5	PD 17-12-20
130	Packaging	1 pcs		11/10/17	0.00	0.00	Packaging3	D.M.L 17-12-20
140	QC21-SA	1 Ea		11/10/17	0.00	0.00	QC21	

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4634-145 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: 138615 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II. (see note 8) Batch # 138649 Expiry Date 10/01/27 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer (see note 9) Batch: 135435

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location:

140 - QC21- Final Inspection - Work Order Release

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D4634-5 <u>5021198</u>	1 <u>5021198</u>	3	0	0
	D4636-5 <u>5021197</u>	1	43	0	0
	D4647-1 <u>5021196</u>	1	4	0	0
	D4664-5 <u>5021194</u>	6	39	0	0
	D4712-1 <u>5021193</u>	1	4	0	0
	D4732-17 <u>5021192</u>	1	0	0	0
	D4732-23 <u>5021190</u>	1	1	0	0
	D4732-27 <u>5021189</u>	1	1	0	0
	D5021-5 <u>5021188</u>	1	1	0	0
	MPNY-750S-9-C <u>5021187</u>	9	570	0	0
	MS20426AD3-4 <u>5021186</u>	4	5,055	0	0
	MS20426AD4-6 <u>5021184</u>	2	2,797	0	0
	MS21059L08 <u>5021183</u>	2	62	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS			
	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐	

Date : _____

Description

S022939

Aft, Center Ceiling Replacement Panel Assembly

PART NO: D4634 – 145
Revision: _____
Operation: Start up Operation
Change No: _____

Mfg Date: 12/15/17
Job No: 167078 – B

MRB (QSI042) Approval _____

Completed By _____

Lead hand / Supervisor Approval Verification _____

QC / QA Coordinator Approval _____

Root Cause			
Environment ☐	No Re-ve ☐		
Design ☐	Operator ☐		
Doc/Data ☐	Offset/Size ☐		
Equip/Tooling ☐	Supplier ☐		
Handling/Pre ☐	Training ☐	Cracks ☐	
Material ☐	Use for Testing ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐
Internal Transport ☐	Poor Information ☐	Cuffs ☐	Contamination ☐
Tribal Knowledge ☐	Rushing ☐	Crushing ☐	Countersink ☐
LOA ☐	Product Improvement ☐	Heat Treat ☐	Cut Too Short ☐
Substation ☐	Process Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐
Past Expiry Date ☐	Manufacturing Process ☐	Marks/Chatter ☐	Drill Holes ☐
Misidentified ☐	Past Due ☐	OTHER : _____	